

What Is Claimed Is:

1. An ornamental manufactured product of the graduated or scalar wound type which comprises a filament of precious material spirally wound on a woven strip of a precious or non-precious material, said manufactured product being characterized by the fact that it is constituted by portions which have different width, wherein the manufactured product has two borders which are not rectilinear but are formed by sections having a course which is converging and/or diverging with respect to the longitudinal axis of the manufactured product.

2. The product according to claim 1 which is a necklace of the graduated or scalar wound type, said necklace being constituted by a filament (5) which is wound on a woven strip (6), said filament and said strip being made of a precious material, characterized by the fact that the necklace has a lamina (1), having a variable width with a value which decreases from the center section (2) towards the two extremities (3), said lamina has a profile (4), said profile in the interior and exterior decreasing in a linear and uniform manner.

3. A process for the preparation of a manufactured product of the graduated or scalar wound type of claim 1, characterized by the fact that it comprises a base (7), said base is constituted by a metallic lamina (8), which is coupled to said strip (6), and said filament (5) is spirally wound on said strip.

4. The process according to claim 3 characterized by the fact that said lamina (8) is made of metal and has a shaped profile like the graduated profile of the manufactured product or the wound necklace.

5. The process according to claim 3 characterized by the fact that the spiralized product with approached spiral with an increasing/decreasing course defined by the profile of said lamina, comprises a filament (5) wound on a center piece or said base (7) said base being constituted by said metallic lamina (8) and by said woven strip (6) which is made of a precious material, is immersed in an acidic bath, whereby said metallic lamina is eliminated due to corrosion.

6. The process according to claim 5 characterized by the fact that the manufactured product constituted by the thread (5) spirally wound on woven strip (6) is subjected to a thickening action of the spirals in order to reacquire the space emptied due to the elimination of said metallic lamina whereby a semi-finished product of the graduated wound type is obtained, said semi-finished product being subsequently subjected to further operations such as beating, polishing, glazing and other operations which transform said semi-finished product into a finished product with specific aesthetic qualities.

7. The process according to claim 3 characterized by the fact that the winding of filament (5) is carried out by mounting the base (7) between two mandrels (9) whereby

said base is put in rotation and said thread wound on a spool (10) is spirally wound on said base, the speed of rotation of the base and the speed of translation of the spool (10) is transmitted from motors (11, 12) which are synchronized by a program of electronic means, said electronic means regulating the working parameters whereby the traction force of a section (5) of the filament being wound is always optimally maintained, and the filament is always kept stretched or under tension.

8. An ornamental manufactured product according to claim 1, characterized by the fact that it has portions of constant width and portions of increasing and/or decreasing width.